

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

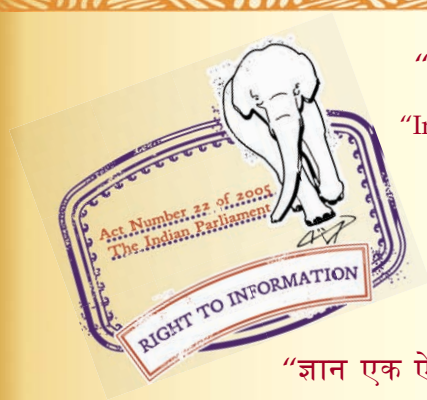
“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 6254 (1971): Side Weft Forks and Grates for Non-automatic Looms [TXD 14: Machinery for Fabric Manufacture]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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Indian Standard

SPECIFICATION FOR SIDE WEFT FORKS AND GRATES FOR NON-AUTOMATIC LOOMS

1. Scope — Prescribes requirements of weft forks and grates for side weft forks with hooked tail for non-automatic looms.

2. Manufacture

2.1 Material

- 2.1.1 Weft fork — Mild steel*.
- 2.1.2 Weft fork grate — Cold-rolled, cold annealed steel sheet or strip*.
- 2.1.3 Weft fork holder — Free cutting quality steel bars or mild steel bars*.
- 2.1.4 Weft fork screw — Mild steel wire*.

2.2 Workmanship and Finish

2.2.1 Weft fork — Plated (nickel or cadmium) or blue finished, as agreed. Weft forks may be either of the following three types:

- a) Welded — Tail and prongs welded to the collar for weft fork screw.
- b) Riveted — Collar for weft fork screw riveted to the tail and prongs cut in one piece.
- c) Solid — One piece.

The weft fork shall be free from any sign of cracks on the surface. The welded portion should be filed smooth. The hole for the screw shall not be out of centre.

2.2.2 Weft fork grate — Zinc, cadmium or nickel plated. The two types of grates in common use are illustrated in Fig. 2. The grates shall be free from cracks particularly at the bent portions. The wires should be held tight. In case of welded grates (Type II in Fig. 2), welded portion, particularly at the outside, should be smooth.

2.2.3 Weft fork holder and screw — Nickel plated. The head of the screw shall be countersunk or round.

3. Requirements

3.1 Shape and Dimensions

3.1.1 Weft fork — See Fig. 1.

Note — The prongs may be corrugated or indented as agreed to between the buyer and the seller.

3.1.2 Weft fork grates — See Fig. 2.

3.1.3 Weft fork holder:

- a) Diameter of rod — 10 mm.
- b) Width of slot for weft fork — 23 ± 1 mm.
- c) The holes shall be co-axial.

Note — The walls of the slot should be thick enough to hold the screw. The thickness of wall in any case should not be less than 3 mm.

3.1.4 Weft fork screws — Diameter $5^{+0}_{-0.2}$ mm. The length of threaded portion shall be 5 mm, Min.

3.2 Balance — When the weft fork is held on its screw (see 3.1.4) or any other wire, it should tilt towards back.

Note — The angle of tilting should normally not exceed 25° .

4. Marking — Each weft fork and grate shall be marked with the following information:

- a) Trade-name or brand of the manufacturer; and
- b) Right hand (RH) or left hand (LH), as the case may be.

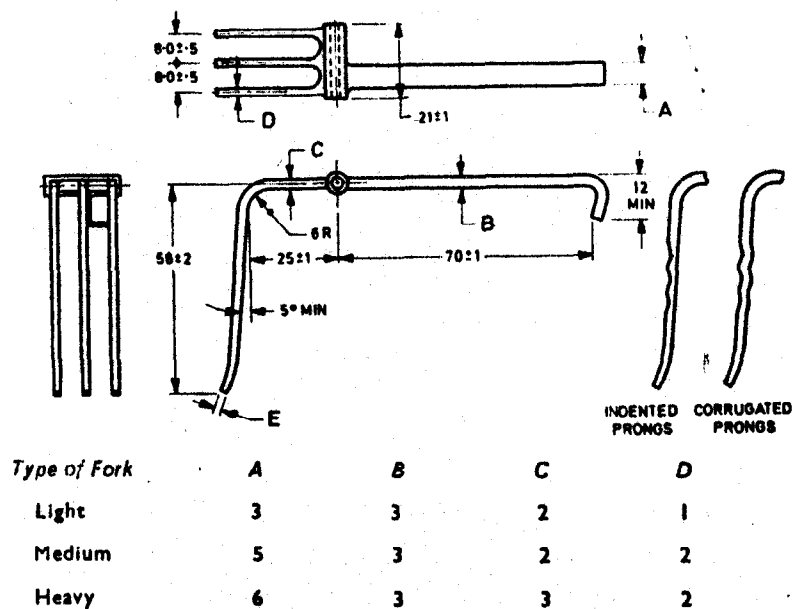
4.1 ISI Certification Marking — Details available with Indian Standards Institution.

*Suitable steels may be selected from IS : 1570-1961 Schedules for wrought steels for general engineering purposes.

Adopted 18 September 1971

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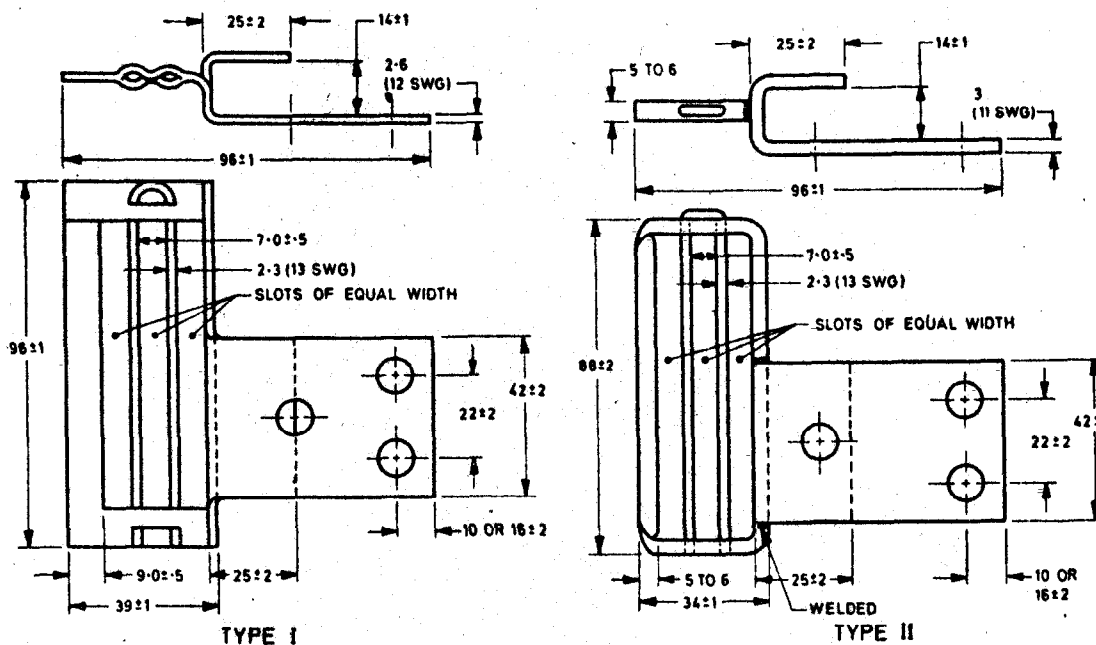
Gr I



Note — These are nominal dimensions. The permissible machining tolerances according to IS: 2102-1969 'Allowable deviations for dimensions without specified tolerances (first revision)' shall, however, be applicable.

All dimensions in millimetres.

FIG. 1 A TYPICAL SIDE WEFT FORK WITH HOOKED TAIL



Note — As prescribed by the buyer, the grate may be provided with square or round tail.

All dimensions in millimetres.

FIG. 2 TYPICAL WEFT FORK GRATES FOR FORK WITH HOOKED TAIL